

Work Order ID 148781

July 07, 2016 4:28:15 PM

148781

Page 1

Item ID: D4854-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Bracket (Replaces P/N G13013-10)

Start Date: 7/7/2016 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 7/7/2016 Req'd Qty: 4.00 ***4***

Customer:

Reference: TO PAINT OLD GENEVA STOCK THAT WAS ANODIZED

Approvals: Process Plan: SH Date: 7/7/16 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4854	A								
160	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	PULL D4854-7 X 4 B104687								
	PAINT AS PER DRAWING								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>S526</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

P.T.O.DAS
38
9-89
SEP 13 2016DAS
6
9-89

Work Order ID 148781

July 07, 2016 4:28:15 PM

148781

Page 2

Item ID: D4854-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Bracket (Replaces P/N G13013-10)
Start Date: 7/7/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/7/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference: TO PAINT OLD GENEVA STOCK THAT WAS ANODIZED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

SEP 14 2016

DAS
21
9-89DAS
21
9-89 SEP 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

July 07, 2016 4:25:31 PM

Page 1

Work Order ID: 148781

148781

Parent Item: D4854-7

D4854-7

Parent Item Name: Lower Bracket (Replaces P/N G13013-10)

Start Date: 7/7/2016

Required Date: 7/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

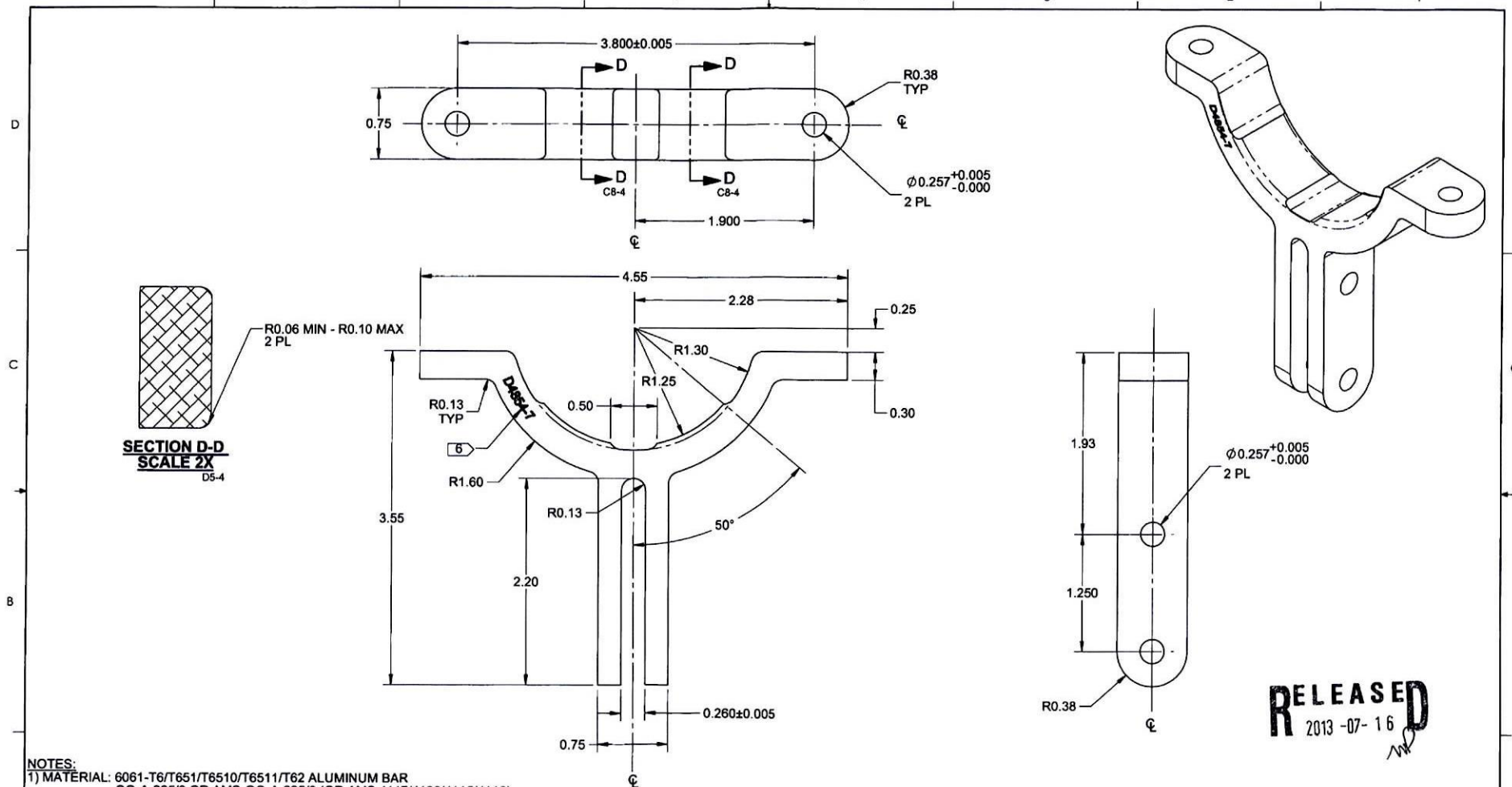
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4854-7		Manufactured	No				Each	0.0000		4			

D4854-7

Lower Bracket (Replaces P/N G13013-10)

D4854-7 x 4 104687 5# 7/7/16

8 7 6 5 4 3 2 1



SECTION D-D
SCALE 2X
D5-4

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.19 lbs
- 8) REPACES GENEVA P/N G13013-10

D4854-7 LOWER BRACKET

DESIGN	<i>OS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>OS</i>			
CHECKED	<i>OS</i>		DRAWING NO.	REV. A
MFG. APPR.	<i>24</i>		D4854	SHEET 4 OF 4
APPROVED	<i>OS</i>		TITLE	SCALE
DE APPR.	<i>OS</i>		LOWER BRACKET	NTS
DATE	13.05.15		COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-07-16

8 7 6 5 4 3 2 1